

**Work Order ID 80231**

Wednesday, February 15, 2012 9:26:49 AM

**\*80231\***

Ship Friday Page 1

Item ID: D3939-3

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Cover

Start Date: 2/15/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 2/17/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: *MF*

Date: 12-02-

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3939

A

100

0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *h*Prog Rev: *h*

2-Deburr as required

*m* 12 02 16 (2)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

*h* 12 02 16 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 80231**

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Item ID: D3939-3

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Cover

Start Date: 2/15/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 2/17/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QS1005 4.1

0.00

**\*130\***

HandFinish

Memo

0.00

Hand Finishing

140

QC7-Inspect Chemical Conversion Coat

0.00

**\*140\***

QC

Memo

0.00

Quality Control

2 BL 12-2-16.

2XPM-12/02/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 80231

Wednesday, February 15, 2012 9:26:49 AM

**\*80231\***

Page 3

Item ID: D3939-3

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Cover

Start Date: 2/15/2012 Start Qty: 2.00 **\*2\***

Cust Item ID:

Required Date: 2/17/2012 Req'd Qty: 2.00 **\*2\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

150

Identify as per dwg & Stock Location: B7

0.00

**\*150\***

Packaging

Memo

0.00

Packaging

12/2/16 2

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

12/2/21 2

mt  
12-02-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Wednesday, February 15, 2012 9:26:48 A

Page 1

Work Order ID: 80231

Parent Item: D3939-3

Parent Item Name: Cover

Start Date: 2/15/2012

Required Date: 2/17/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.02.15 as per dwg rev.A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.050		Purchased	No			100	sf	114.3600	0.0625	0.1315789	M	12-02-16	
6061-T6 .050 Sheet													

## Location

MAT021

## Loc Qty

114.36

## Loc Code

113216

10

114799

89.36

114993

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

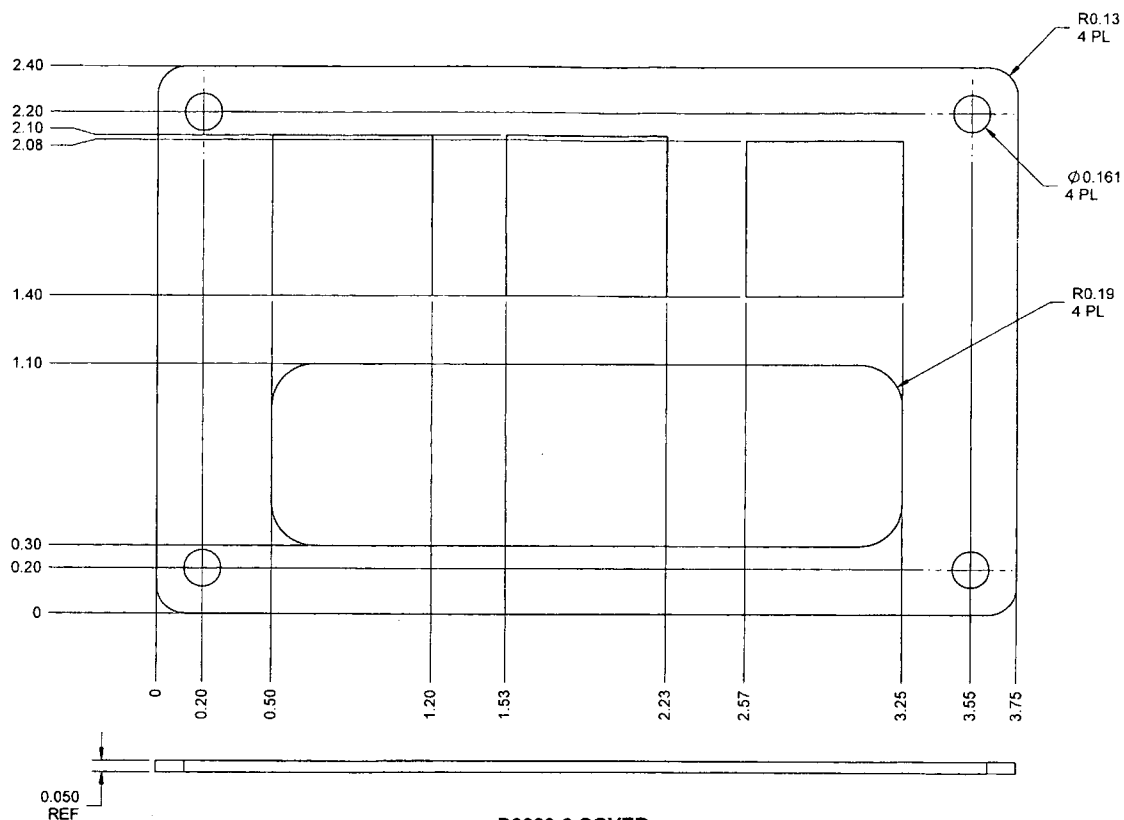
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries





**D3939-3 COVER**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3939-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	D3939	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	COVER	NTS
DATE	09.05.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

# 80231

RELEASED  
-05-14-2009

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DART AEROSPACE LTD		Work Order: 80231
Description: Cover		Part Number: D3939-3
Inspection Dwg: D3939		Rev: A
Page 1 of 1		

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing	Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.161		+0.005-0.001	0.165	✓		V&N	HB-02
3.75		+/-0.030	3.75	✓		V&N	"
3.55		+/-0.030	3.55	✓		V&N	"
3.25		+/-0.030	3.248	✓		V&N	"
2.57		+/-0.030	2.57	✓		V&N	"
2.23		+/-0.030	2.23	✓		V&N	"
1.53		+/-0.030	1.522	✓		V&N	"
1.20		+/-0.030	1.186	✓		V&N	"
0.50		+/-0.030	0.501	✓		V&N	"

Measured by: <i>[Signature]</i>	Date: 12.02.16	Audited by: <i>[Signature]</i>	Date: 12/02/16	Prototype Approval: _____	Date: _____
Rev: A	Date: _____	Change	Revised by: KJ/JLM	Approved	